

Claims

1. Cylinder sleeve for a cylinder crank case, thereby characterized, that the cylinder sleeve (2) includes on one end (5) a contouring (6),

- wherein at least one highest rise (8) of the contouring (6) supports the cylinder sleeve (2) in a pressure injection casting tool against a center sleeve (4).

2. Cylinder sleeve according to Claim 1, thereby characterized, that the contouring (6) of the cylinder sleeve (2) corresponds to the negative shape of a contouring of a corresponding cylinder sleeve (3).

3. Cylinder sleeve according to Claim 2, thereby characterized, that the contouring (6) of the cylinder sleeve (2) exhibits a phase displaced periodic symmetry with the contouring (7) of the corresponding cylinder sleeve (3).

4. Cylinder sleeve according to one of Claims 1 through 3, thereby characterized, that a deepest recess (11) of the cylinder sleeve (2) extends to the lower bottom dead center (11) of a lower most piston ring.

5. Process for producing a cylinder sleeve according to Claim 1, wherein multiple sleeves (2, 3) are divided out from a tube (20), thereby characterized, that by one cutting tool (22) an axial movement is described relative to the tube (20) and the tube (20) is moved circumferentially.

6. Process according to Claim 5, thereby characterized, that the cutting tool (22) is moved in the inside of the pipe (20) and the cutting process occurs from inside towards outside.

7. Process according to Claim 5 or 6, thereby characterized, that the cutting process is carried out by water jet cutting, by laser cutting, by roll separation or precision cutting or stamping.

8. Process according to one of Claims 5 through 7, thereby characterized, that during the cutting process a force (F) is applied against the pipe in both axial directions.